



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT400286
Job Sheet 196374



Part No: RBT400286

Job Qty: 1 pcs

Part Name: Tail Rotor Balance Set B407



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/12/19

Job Tracking No:

Due Date: 7/3/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBT400286 Rev.B IPP Rev. A 19.02.14 New issue DP Verify DD/IPP Rev. B 19.03.06 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	1 pcs	7/3/19		0.00	0.00	Purchasing - 1 Purchasing - 2 Purchasing - 3	JUN 27 2019
110	Packaging 2-1 - Receive - B4B	1 pcs	7/3/19		0.00	0.00	Packaging 2 - 1 - B4B Packaging 2 - 2 - B4B Packaging 2 - 3 - B4B	JUN 27 2019
120	QC 6	1 pcs	7/3/19		0.00	0.00	QC 6 - 9 QC 6 - 68 QC 6 - 61 QC 6 - 40	JUN 27 2019 DAS 40 9-89
130	Packaging 3-1 - Stock - B4B	1 pcs	7/3/19		0.00	0.00	Packaging 3 - 1 - B4B Packaging 3 - 2 - B4B Packaging 3 - 3 - B4B Packaging 3 - 4 - B4B Packaging 3 - 5 - B4B	DAS 28 9-89
140	QC 21 - FG	1 pcs	7/3/19		0.00	0.00	QC 21 - FG - 21 QC 21 - FG - 70 QC 21 - FG - 53	JUN 28 2019 DAS 70 9-89

Part Op 100 - Issue P/O to ARROW TECH MACHINE WORKS ; P/O H804300 - Manufacture RBT400286 as per DWG. -
Descriptions: Certificate of Conformity is required
110 - Certificate of Conformity is required

x1 *blues* June 12, 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT400286P	Tail Rotor Balance Set B407	1 Ea (1 ea)	100-Purchasing	5194298

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBT400286P	1	0	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S194299



Part: RBT400286

Job No: 196374

Serial No/Batch: S194299

Revision: B

Inspector:

Exp Date:

Instructions:

Date: 06/27/19

Part Specifications

Specifications could not be found.

Plex 6/12/19 11:23 AM dart.lussier.patrick



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ORDER ACKNOWLEDGEMENT

CUSTOMER

Customer Code: CSOUT12

Sold To: South Florida Water Management Dist
PO Box 24682
West Palm Beach, FL 33416-4682
USA
Phone: (561) 317-2092

Ship To: South Florida Water Management Dist
1500 South Perimeter Road
West Palm Bay, FL 33406
USA

ORDER

Order No : 16448

Date: 6/12/19

Ship-To Contact: David Reinert

Email: dreinert@sfwmd.gov

Cust PO No: 4500113538

FOB: Shipping Point

Ship Via: TBA - to be advised

Freight Terms: PrePaid

Terms: Net 30

INCO Terms: Ex Works

Order Taker: Lacey Cantin

Order Taker Phone:

Order Taker Email: lcantin@dartaero.com

Line No	Due Date	Ship Date	Part	Description/Note	Quantity	Unit	Price	Unit	Extended Price
1	8/21/19	8/21/19	RBT400286	Tail Rotor Balance Set B407	1	pcs	\$7,381.00USD	pcs	\$7,381.00 USD
				5% Gold+ Discount			-5.00		\$-369.05
Sub Total									\$7,011.95 USD
Grand Total									\$7,011.95 USD

2 weeks LT

ORDER NOTES

TAX ID#59-74-0072K

6/12/2019

ORDER ACKNOWLEDGEMENT

Remit to: DART Aerospace Ltd., 1270 Aberdeen Street, Hawkesbury, Ontario K6A 1K7 Canada

Tel: 613 632 5200

Fax: 613 632 5246

accounting@dartaero.com

GST/HST 10127 2607

Note: A minimum 15% restocking fee is applicable. Custom items are non-refundable. Full warranty details are available at www.dartaerospace.com

International / US Wires:

Swift Code: CHASUS33 Bank Routing #: 021000021 Account #: 133281000

Bank Name: JPMorgan Chase Bank 201 St. Charles Ave., New Orleans, LA USA 70170

Account Name: DART Aerospace Ltd.

Notification October 2018: Our banking information has remained unchanged

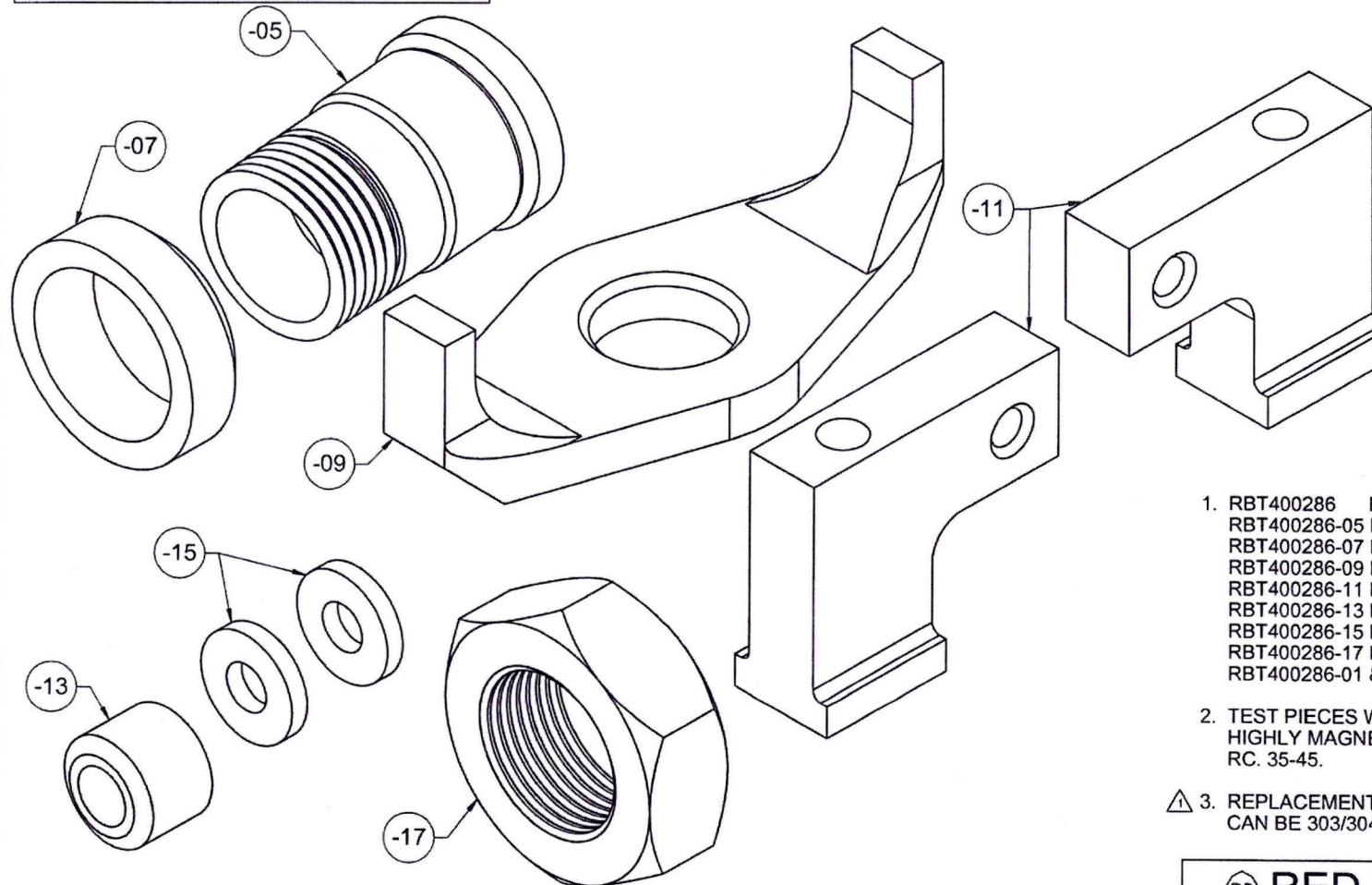
Latest Revision Provided Unless Otherwise Requested

Plex 6/12/19 9:56 AM dart.cantin.lacey

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
B	UPDATED ITEM -17 B/O INFORMATION OR SPECIFICATIONS COLUMN	03/05/19	MBB

ECN 19-623



NOTES

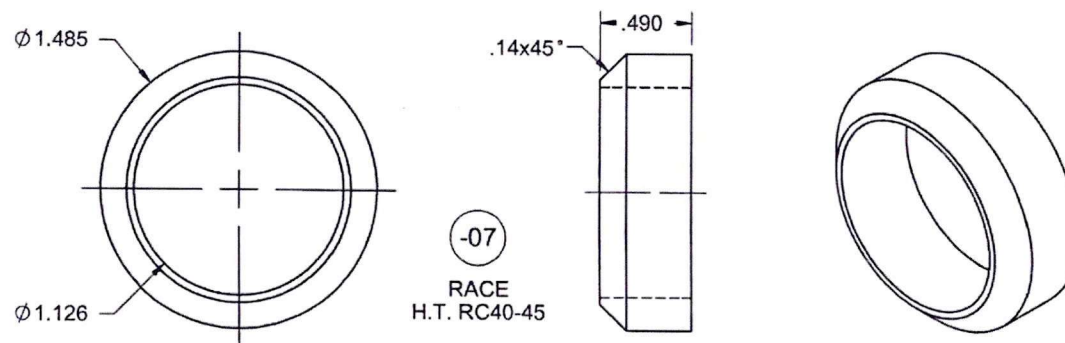
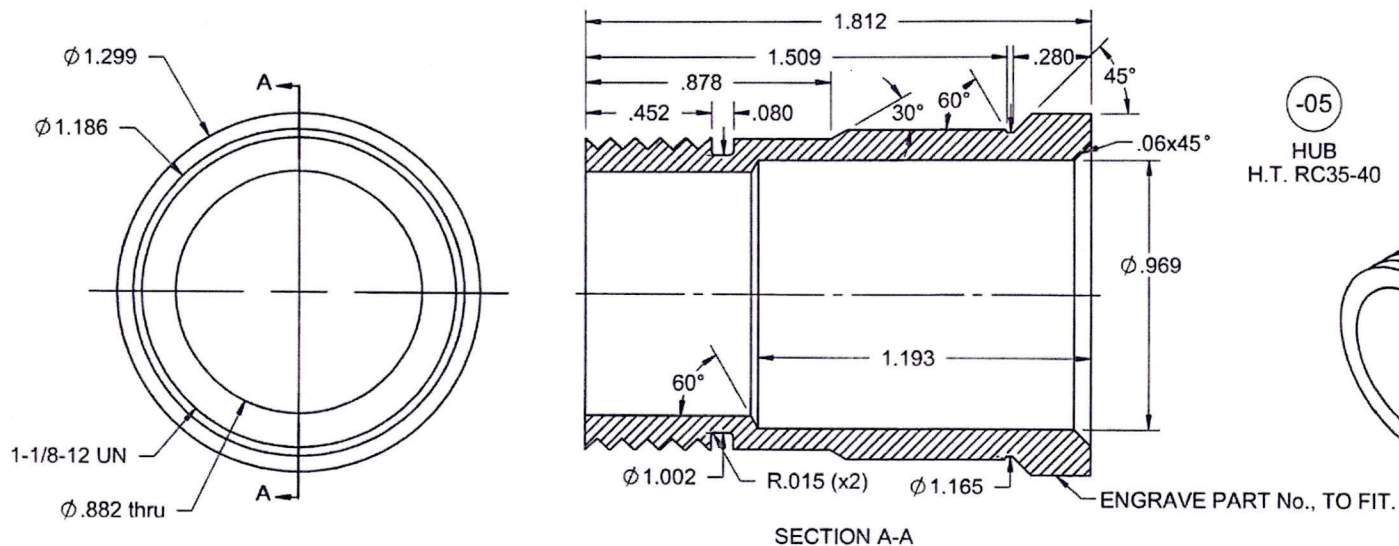
1. RBT400286 REPLACES 206-210-100-103
RBT400286-05 REPLACES 206-210-100-105
RBT400286-07 REPLACES 206-210-100-107
RBT400286-09 REPLACES 206-210-100-109
RBT400286-11 REPLACES 206-210-100-111
RBT400286-13 REPLACES 206-210-100-113
RBT400286-15 REPLACES 206-210-100-115
RBT400286-17 REPLACES 90-094-10;
RBT400286-01 & 03 No.'s ARE NOT USED.
2. TEST PIECES WERE STAINLESS STEEL,
HIGHLY MAGNETIC, AND HEAT TREATED
RC. 35-45.
3. REPLACEMENT MATERIAL FOR 17-4 S.S.
CAN BE 303/304 S.S. WITH OUT HEAT TREATING.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-05	1	HUB	17-4 S.S.	$\phi 1-3/8 \times 2$	2
			-07	1	RACE	17-4 S.S.	$\phi 1-1/2 \times 3/4$	2
			-09	1	GUIDE	6061	$1-3/8 \times 2 \times 4-3/8$	3
			-11	2	STOP	6061	$1 \times 1-3/4 \times 2-1/4$	4
			-13	1	SPACER	17-4 S.S.	$\phi 3/4 \times 3/4$	5
			-15	2	WASHER	17-4 S.S.	$\phi 7/8 \times 5/16$	5
			-17	1	JAM NUT	CAD PLATE STEEL	$1-1/8 \times 12 \text{ UNC (McMaster\#93839A858 OR EQUIV.)}$	1
			-	-	-	-	-	-

RED BARN MACHINE	
TITLE	
TAIL ROTOR BALANCE SET	
DWG NO. RBT400286	
REV B	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX $\pm .005$ METRIC X $\pm .1\text{mm}$.XX $\pm .01$ FRACTIONS $\pm 1/32$.X $\pm .1$ ANGLES $\pm 5^\circ$	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	DATE
NTS	3-2-10
SHEET 1 of 5	

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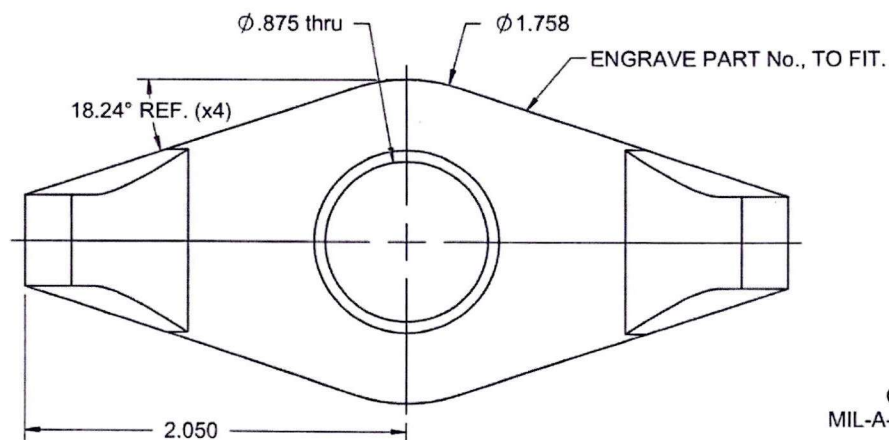
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
-	--	-	-



RED BARN MACHINE	
TITLE: TAIL ROTOR BALANCE SET; HUB AND RACE	
DWG NO. RBT400286-05 & 07	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	DRAWN BY: PERRITT
DECIMALS .XXX ± .005	APPROVED: [Signature]
METRIC .X ± .1mm	HEAT TREAT: SEE PART
FRACTIONS ± 1/32	FINISH SPEC: SEE PART
ANGLES ± .5°	USED ON MODEL: BELL 206
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE: NTS	DATE: 3-2-10
SHEET: 2 of 5	

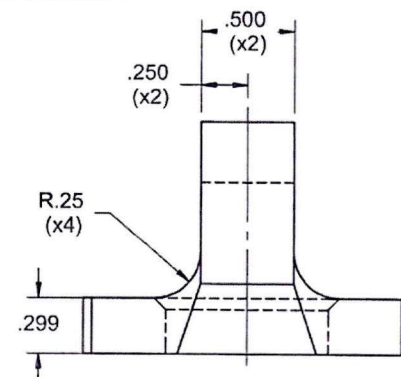
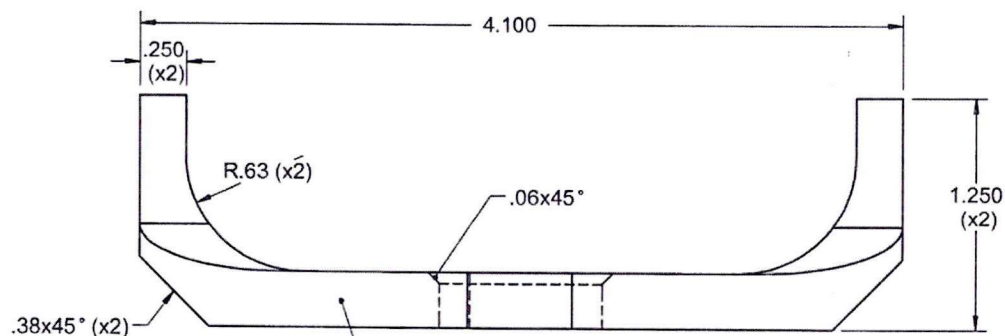
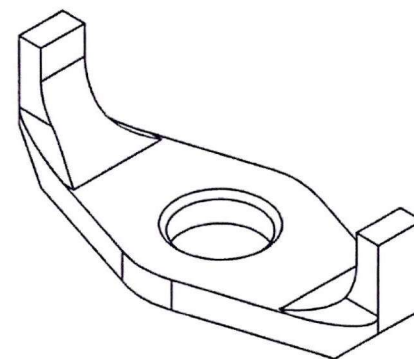
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
-	--	-	-



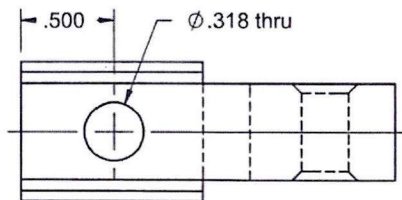
(-09)

GUIDE
CLEAR ANODIZE
MIL-A-8625, TYPE I, CLASS I



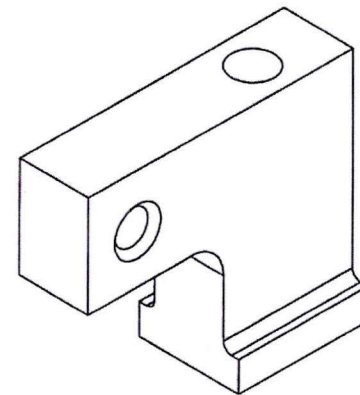
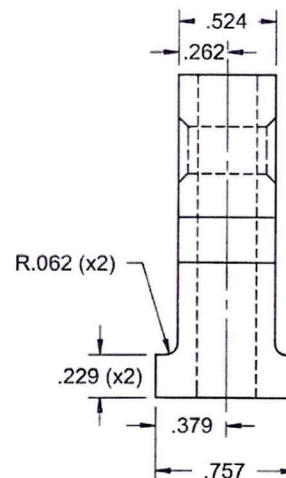
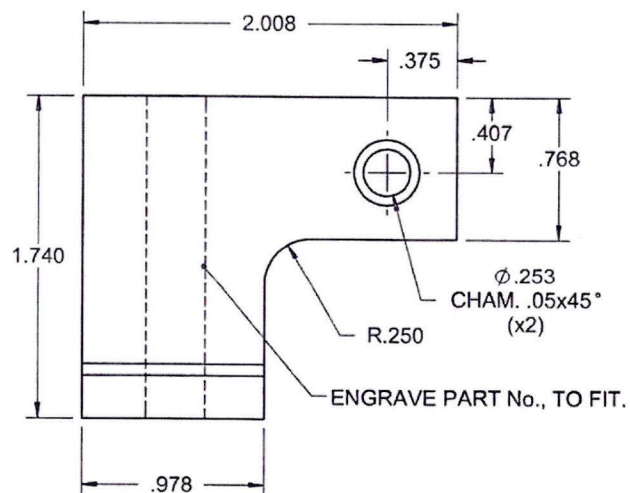
RED BARN MACHINE		TITLE	
		TAIL ROTOR BALANCE SET; GUIDE	
DWG NO.		REV	
RBT400286-09		B	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED:	
DECIMALS	METRIC	HEAT TREAT	
.XXX ± .005	X ± .1mm	SEE PART	
.XX ± .01	FRACTIONS ± 1/32	FINISH	
.X ± .1	ANGLES ± .5°	SEE PART	
UNLESS OTHERWISE SPECIFIED		USED ON MODEL	
1. BREAK ALL SHARP EDGES		BELL 206	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	DATE	SHEET	
NTS	3-2-10	3 of 5	

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
-	--	-	-	-



(-11)

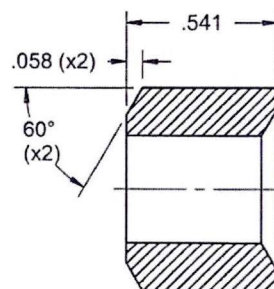
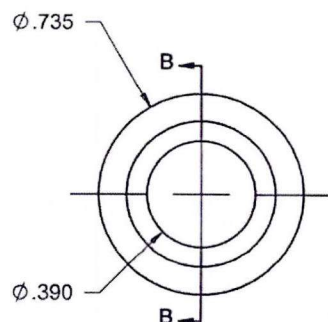
STOP
CLEAR ANODIZE
MIL-A-8625,
TYPE I, CLASS I



 RED BARN MACHINE			
TITLE TAIL ROTOR BALANCE SET; STOP			
DWG NO. RBT400286-11			REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS METRIC .XXX ± .005 .X ± .1mm .XX ± .01 FRACTIONS ± 1/32 .X ± .1 ANGLES ± 5°		DRAWN BY: PERRITT APPROVED  HEAT TREAT SEE PART FINISH SPEC SEE PART	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR 015 R		USED ON MODEL BELL 206	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	NTS	DATE	3-2-10
		SHEET	4 of 5

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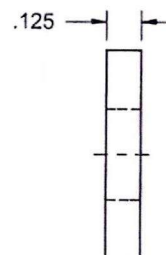
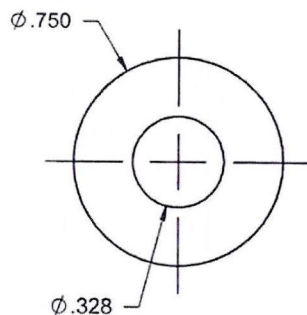
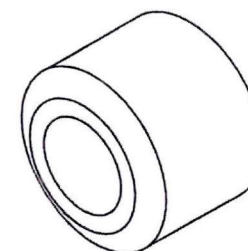
REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
-	--	-	-



SECTION B-B

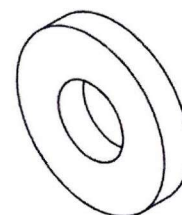
-13

SPACER
H.T. RC. 40-45
BEAD BLAST



-15

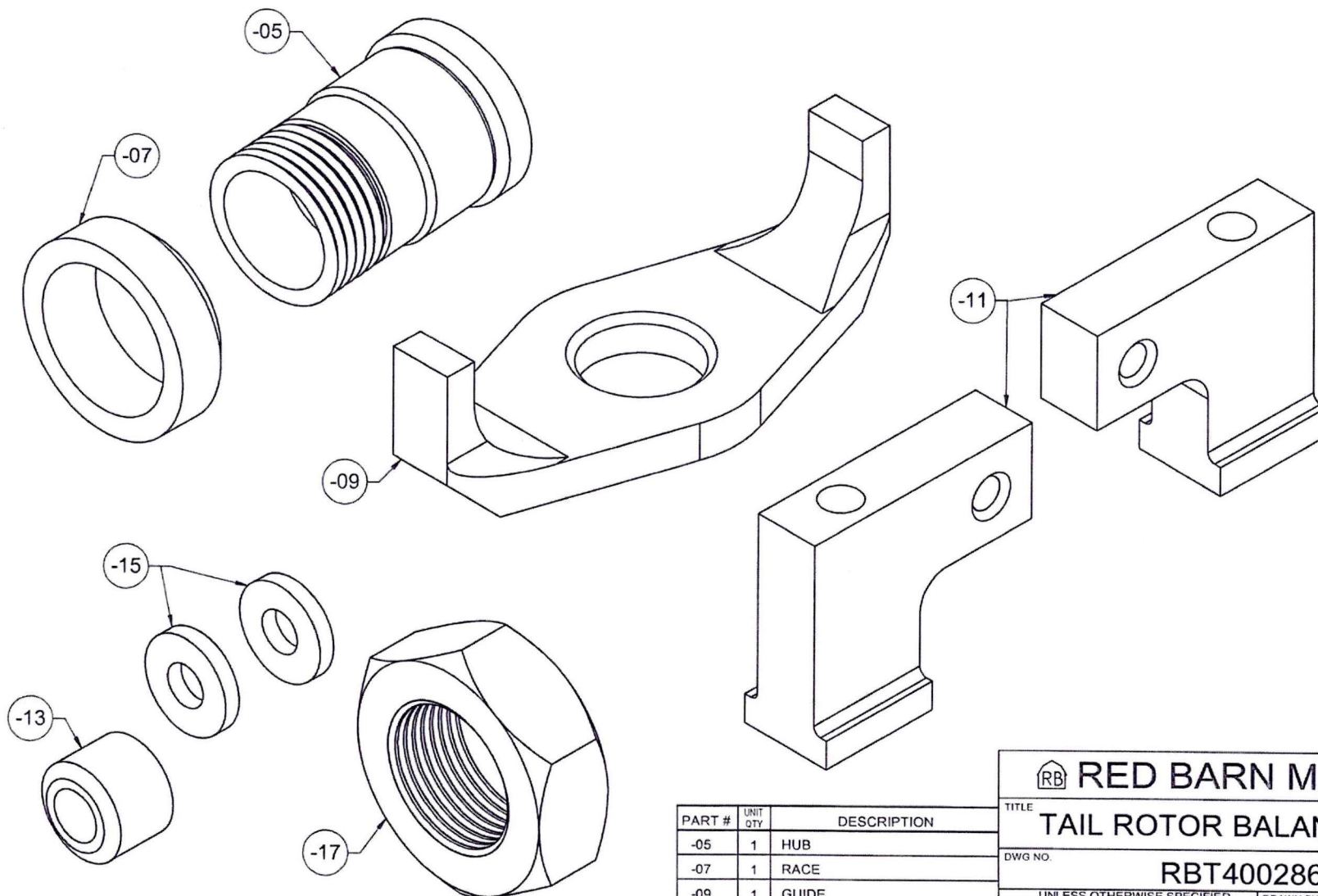
WASHER
H.T. RC. 35-40



 RED BARN MACHINE	
TITLE TAIL ROTOR BALANCE SET; SPACER & WASHER	
DWG NO. RBT400286-13 & 15	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	DRAWN BY: PERRITT
DECIMALS	APPROVED: 
.XXX ± .005	METRIC X ± .1mm
.XX ± .01	FRACTIONS ± 1/32
.X ± .1	ANGLES ± .5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 0.15 x 45° PR. 0.15 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 3-2-10
SHEET 5 of 5	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
-	-	-	-



PART #	UNIT QTY	DESCRIPTION
-05	1	HUB
-07	1	RACE
-09	1	GUIDE
-11	2	STOP
-13	1	SPACER
-15	2	WASHER
-17	1	JAM NUT
-	-	-

 RED BARN MACHINE		TITLE	
		TAIL ROTOR BALANCE SET	
DWG NO.		REV	
RBT400286		B	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 ANGLES ± .5° METRIC .X ± .1mm UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		DRAWN BY: PERRITT APPROVED:  HEAT TREAT: SEE PART FINISH SPEC: SEE PART USED ON MODEL: BELL 206	
SCALE NTS	DATE 3-2-10	SHEET 1 of 1	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB043700



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB043700

PO Date: 6/12/19

Due Date: 7/3/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	196374	RBT400286P			Tail Rotor Balance Set B407	Firmed -		7/3/19	1 Ea	0 Ea	1 Ea	\$1,811.00/Ea	\$1,811.00
Grand Total: \$1,811.00													

DAS
40
9-89

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

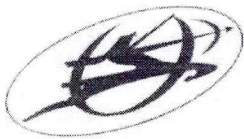
A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 6/12/19 11:25 AM dart.lussier.patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 602

Date: 6/25/2019
PO Ref: HB043700 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty
1 ✓

Item
TAIL ROTOR BALANCE SET

Part No.
RBT400286 REV B ✓

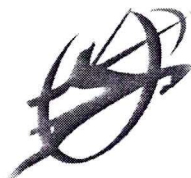
RECEIVED

JUN 26 2019

DART AEROSPACE LTD.

Received by: _____
Packaged by: J.M.C.
Checked by: AMP

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB043700 ✓ Dated: 6/25/2019

Our Order / Job No: HB043700-1AWT Order Qty:1 ✓

Part Name: TAIL ROTOR BLANCE SET B407

Part Number RBT400286 ✓

DAS
40
9-89

Lot Size: N/A Ship Date: 6/25/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBT400286 Rev: REV B

Material Size and Type: -5, -7, -13, 15/ 303 SS; -9, -11/6061 ALUM.

Material Specifications: 303: ASTM 5640; ALUM.: ASTM B221

Heat Treatment: N/A

Plating/Finish: CLEAR ANODIZE: MIL-A-8625F, TYPE 2 CLASS 1

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 6/25/19

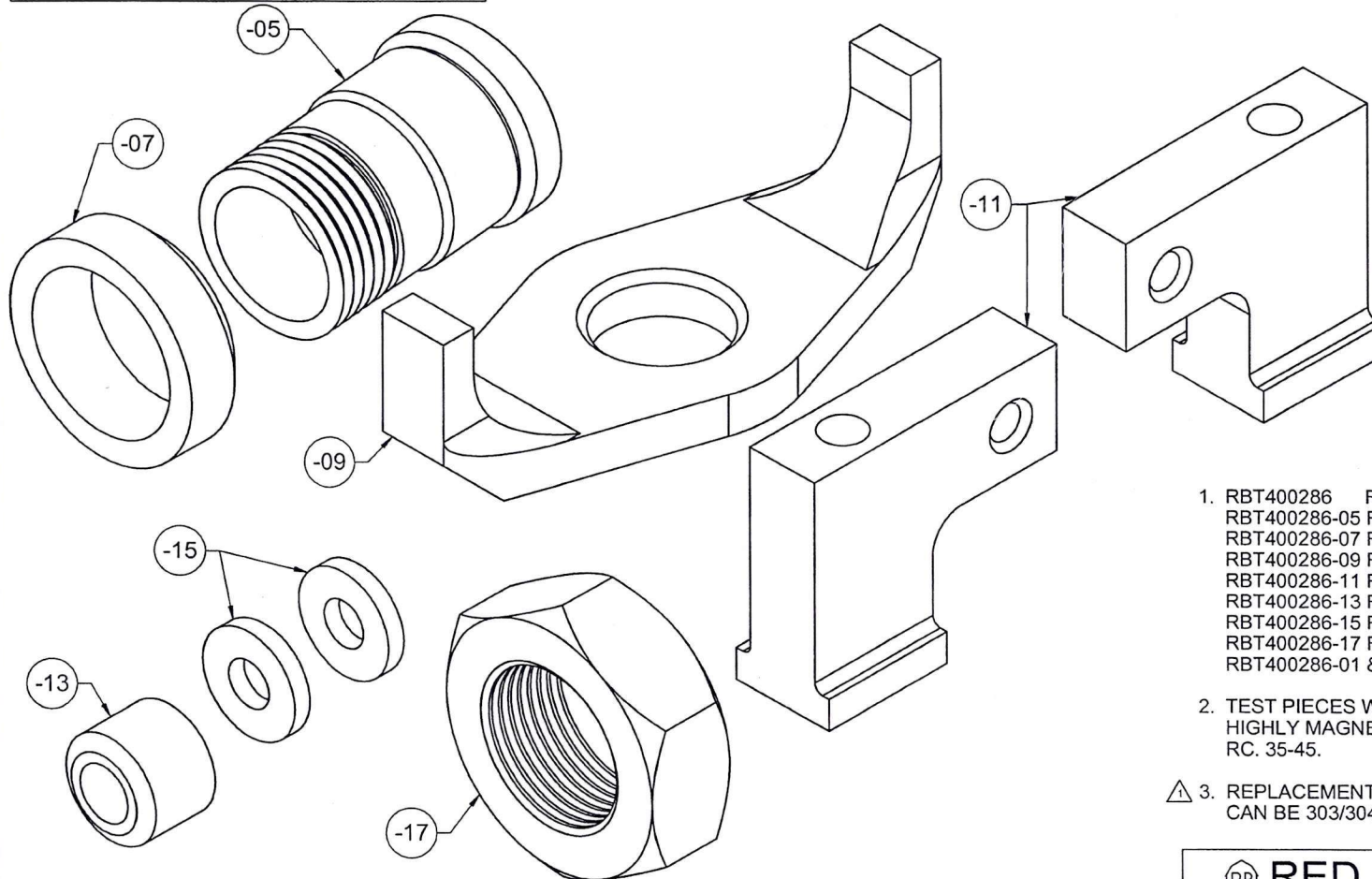
Signed: Herbert M. Galt

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
B	UPDATED ITEM -17 B/O INFORMATION OR SPECIFICATIONS COLUMN	03/05/19	MBB

ECN 19-623



NOTES

1. RBT400286 REPLACES 206-210-100-103
RBT400286-05 REPLACES 206-210-100-105
RBT400286-07 REPLACES 206-210-100-107
RBT400286-09 REPLACES 206-210-100-109
RBT400286-11 REPLACES 206-210-100-111
RBT400286-13 REPLACES 206-210-100-113
RBT400286-15 REPLACES 206-210-100-115
RBT400286-17 REPLACES 90-094-10;
RBT400286-01 & 03 No.'s ARE NOT USED.

2. TEST PIECES WERE STAINLESS STEEL, HIGHLY MAGNETIC, AND HEAT TREATED RC. 35-45.

3. REPLACEMENT MATERIAL FOR 17-4 S.S. CAN BE 303/304 S.S. WITH OUT HEAT TREATING.

RED BARN MACHINE

TITLE

TAIL ROTOR BALANCE SET

DWG NO. **RBT400286** REV **B**

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS METRIC
.XXX ± .005 .X ± .1mm
.XX ± .01 FRACTIONS ± 1/32
.X ± .1 ANGLES ± 5°

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

SCALE **NTS** DATE **3-2-10** SHEET **1 of 5**

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-05	1	HUB	17-4 S.S.	Ø 1-3/8 x 2	2
		-07	1	RACE	17-4 S.S.	Ø 1-1/2 x 3/4	2
		-09	1	GUIDE	6061	1-3/8 x 2 x 4-3/8	3
		-11	2	STOP	6061	1 x 1-3/4 x 2-1/4	4
		-13	1	SPACER	17-4 S.S.	Ø 3/4 x 3/4	5
		-15	2	WASHER	17-4 S.S.	Ø 7/8 x 5/16	5
		-17	1	JAM NUT	CAD PLATE STEEL	1-1/8 X 12 UNC (McMaster#93839A858 OR EQUIV.)	1
ASSY #		-	-	-	-	-	-